



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5155-11**Job Sheet 197959****Part No:** D5155-11**Job Qty:** 5 pcs**Part Name:** Co-Pilot Collective Head (212)**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 7/18/19**Job Tracking No:****Due Date:** 8/16/19**Created By:** Marie Lajeunesse**Type:** Stock**Description:**

Note: DWG REV B IPP REV.A NEW ISSUE JFS 15/01/14 VERIFIED BY: JLM IPP REV:B 15.07.02 AS PER DWG
REV.B DD VERF:JLM

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	5 pcs	8/16/19	8/16/19	0.00	0.00	Bandsaw - 1		JLM 19-09-28
110	HAAS 5 Axis - B4B	5 pcs	8/16/19	8/16/19	0.09	8.47	HAAS - 5 - B4B		
120	QC 1	5 pcs	8/16/19	8/16/19	0.00	0.00	QC 1 - 14		
							QC 1 - 85		
							QC 1 - 8		
							QC 1 - 9		
130	QC 8	5 pcs	8/16/19	8/16/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		B.e 19-10-01
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		

**Container No:** S218088**Part:** D5155-11**Job No:** 197959**Serial No/Batch:** S218088**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's**Date:** 09/28/19

Dart Aerospace Ltd.
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CANADA
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7/18/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

				QC 8 - 57	
150	Outsource - 4 - Anodize	5 pcs	8/16/19	GRO002-VC	5 <i>POH/3044719</i> <i>OK</i> <i>15/</i> <i>OCT 08 2019</i>
155	Packaging 2-1 - Receive - B4B	5 pcs	8/16/19	0.00 0.00	Packaging 2 - 1 - B4B
					Packaging 2 - 2 - B4B
					Packaging 2 - 3 - B4B
					Packaging 2 - 5 - B4B
					Packaging 2 - 4 - B4B
					Packaging 2 - 6 - B4B
					Packaging 2 - 7 - B4B
					Packaging 2 - 8 - B4B
					Packaging 2 - 9 - B4B
					Packaging 2 - 10 - B4B
					Packaging 2 - 11 - B4B
					Packaging 2 - 12 - B4B
					Packaging 2 - 13 - B4B
					Packaging 2 - 14 - B4B
					Packaging 2 - 15 - B4B
					Packaging 2 - 16 - B4B
					Packaging 2 - 17 - B4B
					Packaging 2 - 18 - B4B
					Packaging 2 - 19 - B4B
					Packaging 2 - 20 - B4B
					Packaging 2 - 21 - B4B
					Packaging 2 - 22 - B4B
					Packaging 2 - 23 - B4B
					Packaging 2 - 24 - B4B
					Packaging 2 - 25 - B4B
					Packaging 2 - 26 - B4B
					Packaging 2 - 27 - B4B
					Packaging 2 - 28 - B4B
					Packaging 2 - 29 - B4B
					Packaging 2 - 30 - B4B
					Packaging 2 - 31 - B4B
					Packaging 2 - 32 - B4B
					Packaging 2 - 33 - B4B
					Packaging 2 - 34 - B4B
					Packaging 2 - 35 - B4B
					Packaging 2 - 36 - B4B
158	QC <i>56</i>	5 pcs	8/16/19	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24
					QC 5 - 3
					QC 5 - 43
					QC 5 - 49
					QC 5 - 51
					QC 5 - 58
					QC 5 - 68
					QC 5 - 9
					QC 5 - 50
					QC 5 - 30
					QC 5 - 40
					QC 5 - 61
					QC 5 - 81
160	Packaging 3-1 - Stock - B4B	5 pcs	8/16/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B

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				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	pc 57375
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
170 QC 21 - SA	5 pcs	8/16/19	0.00 0.00	QC 21 - SA - 21	DAS OCT 23 2019
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-89

Part Op 100 - CUT BLANK AT 4.900"

Descriptions: 110 - (HAAS CNC vertical machine #5), MACHINE AS PER DWG & FOLIO FB349/ D5155-11

120 - (QC1- Inspection performed by CMM), Inspect on CMM as per folio CMM033.

130 - (QC8- Inspect parts - second check)

150 - (Outsource process-Anodize per QSI017 4.1.10.1), ISSUE P/O: _____ ANODIZE BLACK AS PER MIL

SPEC AND DWG C OF CO IS REQUIRED

155 - (Receive & Inspect for Damage & Mat'l Certs)

158 - (QC5- Inspect part completeness to step on W/O)

160 - (Identify as per dwg & Stock Location: _____)

170 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M6061T6B2.500X03.500	6061-T6 Bar 2.50 X 3.50	2.0450 ft (.409 ea)	100-Bandsaw - 1	5214489 2.083'

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B2.500X03.500	2	5	0

Part Specifications	
Specifications could not be found.	

DART AEROSPACE LTD		Work Order:	197955
Description: Co-Pilot Collective Head (212)		Part Number:	D5155-11
Inspection Dwg: D5155	Rev: B	Page 1 of 2	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.800	+0.010/-0.000	2.804	✓		Height gauge	
1.83	+/-0.030	1.830	✓		"	
R0.19	+/-0.030	.190	✓		Rad gauge	
21°	+/-0.5°	21°	✓		Protractor	
0.227	+/-0.010	.226	✓		SL-10	VERN
1.850	+/-0.010	1.847	✓		"	
Ø0.125 x 0.350	+0.004/-0.001 x +/-0.010	.126 x .348	✓		"	
21°	+/-0.5°	21°	✓		Protractor	
2.547	+/-0.005	2.546	✓		SL-10	VERN
0.35	+/-0.030	.355	✓		"	
R0.25	+/-0.030	.250	✓		Rad gauge	
0.35	+/-0.030	.346	✓		SL-10	VERN
0.06	+/-0.030	.063	✓		"	
0.33	+/-0.030	.327	✓		"	
R0.25	+/-0.030	.250	✓		Rad gauge	
1.500	+/-0.010	1.500	✓		Height gauge	
Ø0.150	+0.005/-0.001	.152	✓		SL-10	
1.450	+/-0.010	1.449	✓		Height gauge	
R0.30	+/-0.030	.300	✓		Rad gauge	
R0.03	+/-0.030	.031	✓		"	
0.100	+/-0.010	.100	✓		SL-10	VERN
3.000	+/-0.010	2.998	✓		"	
0.59	+/-0.030	.590	✓		"	
1.82	+/-0.030	1.820	✓		"	
R0.30	+/-0.030	.300	✓		Rad gauge	
R0.25	+/-0.030	.250	✓		"	
Ø0.150	+0.005/-0.001	.153	✓		SL-10	VERN
R0.25	+/-0.030	.250	✓		R-gauge	
2.400	+/-0.005	2.400	✓		SL-10	VERN
0.300	+/-0.010	.299	✓		"	
1.450	+/-0.010	1.450	✓		Height gauge	
1.750	+/-0.010	1.750	✓		SL-10	VERN
Ø0.150	+0.005/-0.001	.152	✓		"	
2.70	+/-0.030	2.701	✓		"	
2.500	+/-0.010	2.502	✓		"	
2.20	+/-0.030	2.200	✓		"	
R0.30	+/-0.030	.300	✓		Rad gauge	

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐				DEPARTMENT/PROCESS Cross tube ☐ ☐ ☐ Eng. (Non-AW) ☐ ☐ ☐ Small Fab ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ Finishing ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ Skid-tube ☐ ☐ ☐ Engineering ☐ ☐ ☐ Machining ☐ ☐ ☐ Water Jet ☐ ☐ ☐ Large Fab ☐ ☐ ☐ Supplier ☐ ☐ ☐ Quality ☐ ☐ ☐				Date : _____ Sequence #: _____ QTY Affected : _____ MRB (QS1042) _____																											
Description Work Order Deviation		Disposition		Completed By		Lead hand / Supervisor		QC / QA Coordinator																													
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Grimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table> Other/Details: _____								Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Grimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
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Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
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Tel (613) 632-5200

PURCHASE ORDER

POHB044719



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044719

PO Date: 10/8/19

Due Date: 10/16/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Lavoie, Chantal
Phone: 613-623-5200 Ext: 242
Fax: 613-632-1053
clavoie@dartaero.com

OCT 11 2019

Via: Ground

Pyrm Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	197959	D5155-11	Co-Pilot Collective Head (212) Various STC's (Outsource process) ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 NOTE: C OF C REQUIRED	Firmed KS	-	10/16/19	5 pcs	0 pcs	5 pcs	\$24.00/pcs	\$120.00
											OCT 16 2019
											Grand Total: \$120.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/11/19 9:52 AM Dart.Lavoie.Chantal

**Certificat de Conformité / Certificate of Compliance**
(023086-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.groupaltech.com

Bon de Livraison / Packing Slip**023086 - 1**

Livré à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
BUYER:

Date expédition Ship date		Créé Par Generated By		Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.				
16-Oct-2019		Jigar Patel				POHB044719				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)			CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir / Back Order
1	D5155-11 Rev.	D5155-11 ANO-BLACK [ANODIZE BLACK] AS PER MIL-A-8625F TYPE - I OR IB OR IC OR II OR IIB, CLASS - 2			ANODIZE CH	5	5	0	0	DA 0 40 9:39

RECEIVED
OCT 16 2019
DART AEROSPACE LTD.

RECEIVED**OCT 16 2019****DART AEROSPACE LTD.**

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual ThicknessInspecteur Qualité
Quality InspectorRéçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.